

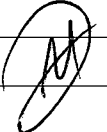
Work Order ID 163121

Wednesday, June 21, 2017 3:33:53 PM

163121

Page 1

Item ID: D5350-043 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Aft Beam Assembly
 Start Date: 7/10/2017 Start Qty: 3.00 ***3*** Cust Item ID:
 Required Date: 7/20/2017 Req'd Qty: 3.00 ***3*** Customer:
 Reference:

Approvals: Process Plan:  Date: JUN 21 2017 Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D5350	D

100	Cut blanks as per folio	0.00							
100									
Bandsaw	Memo	0.25							
Jeaspa Bandsaw	Cut blank at 66.800"								

DAS
14
9-89

17/02/14

110		0.00							
110									
HAAS 4	Memo	4.25							
HAAS CNC vertical machine #4	1-Machine per folio FB448 (D5350-3)								
	DWG REV: <u>2</u>								
	FOLIO REV: <u>AA</u>								

17/07/18

2- Deburr and break all sharp edge as per dwg.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐			
Design ☐	☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐			
Doc/Data ☐	☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐			
Equip/Tooling ☐	☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐			
Handling/Pre ☐	☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐			
Material ☐	☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐			
Internal Transport ☐	☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐			
Tribal Knowledge ☐	☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐			
LOA ☐	☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐			
Substation ☐	☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐			
Past Expiry Date ☐	☐	Manufacturing Process ☐	OTHER :						
Misidentified ☐	☐	Past Due ☐							

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Page 2

17/07/19

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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WORK ORDER NON-CONFORMANCE / UPDATE

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OTHER :																																																																									

Work Order ID 163121

Wednesday, June 21, 2017 3:33:53 PM

163121

Page 4

Item ID: D5350-043 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Aft Beam Assembly
 Start Date: 7/10/2017 Start Qty: 3.00 ***3*** Cust Item ID:
 Required Date: 7/20/2017 Req'd Qty: 3.00 ***3*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 *180* QC Quality Control	QC7-Inspect Chemical Conversion Coat Memo	0.00 0.03							<u>2</u> <u>φ</u> <u>17-07-24</u> DAS 34 9.89
190 *190* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum <u>M 139014.</u> Memo MASK HOLES AS PER NOTE 8 SHEET 4 START TIME: <u>7:50</u> OVEN TEMPERATURE: <u>320°</u> FINISH TIME: <u>8:20.</u>	0.00 0.48							<u>2</u> <u>φ</u> <u>17-07-25.</u> DAS 34 9.89
200 *200* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.03							<u>2x</u> <u>17/07/25</u> DAS 36 9.89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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DQA: _____ Date: _____



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Work Order ID 163121

Wednesday, June 21, 2017 3:33:53 PM

163121

Page 6

Item ID: D5350-043

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Aft Beam Assembly

Start Date: 7/10/2017 Start Qty: 3.00

3

Cust Item ID:

Required Date: 7/20/2017 Req'd Qty: 3.00

3

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

240

QC21- Final Inspection - Work Order Release

0.00

240

QC

Memo

0.30

Quality Control

DAS
21
9-89

JUL 26 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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								Lead hand / Supervisor Approval Verification																	
										QC / QA Coordinator Approval															
Root Cause		FAULT CATEGORY																							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : _____																			

Picklist Print

Wednesday, June 21, 2017 3:33:52 PM

Page 1

3

Work Order ID: 163121

163121

Parent Item: D5350-043

D5350-043

Parent Item Name: Aft Beam Assembly

Start Date: 7/10/2017

Required Date: 7/20/2017

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP REV:A 15.12.11 NEW ISSUE DD VERF:JLM IPP
REV:B 16.01.25 rev.a dwg DD VERF:JLM IPP REV:C
16.06.30 DWG REV.B DD VERF:JLM IPP REV:D 17.01.09
DWG REV.c DD VERF:JLM IPP REV:E DWG. REV.D
17/04/11 JFS VERIFIED BY: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
CBL-1240		Purchased	No			210	f	291.3597	5.42	17.11579			DAS
CBI -1240									**			JUL 25 2017	19 9-89
Cable													

Location

Loc Qty

Loc Code

GA

291.3597488

m136491

47.6052488

m136852

43.7545

m137684

200

11,46

FOR D2690-8
CUT TO 13.000"

CBL-460

Purchased

No

210

Each

142.0000

10

30

CBI -460

Loop Sleeve

**

JUL 25 2017

DAS
19
9-89

Location

Loc Qty

Loc Code

GA

142

m136852

10

m137339

132

28

FOR D2690-8

D5346-3

Manufactured

No

210

Each

39.0000

4

12

D5346-3

Bushing

**

JUL 25 2017

DAS
19
9-89

Location

Loc Qty

Loc Code

ST165

39

161327

39

8

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

Wednesday, June 21, 2017 3:33:52 PM

Page 2

Work Order ID: 163121

163121

Parent Item: D5350-043

D5350-043

Parent Item Name: Aft Beam Assembly

Start Date: 7/10/2017

Required Date: 7/20/2017

Start Qty: 3.00

Required Qty: 3.00

M6061T6B1.000X06.00
0

Purchased No

100 f

19.1100 5.57 17.58947

M6061T6B1 000X06 000

6061T6 BAR 1.00 X 6.00

**

Location

Loc Qty

Loc Code

MAT003

19.11

m130013

2.7

m134705

7.83

m137365

8.58

210 Each

0.0000

1 3

**

JUL 25 2017

DAS

19

9-89

DAS

19

9-89

D5350-5

Manufactured No

D5350-5

Adapter

MS17984-C412

Purchased No

MS17984-C412

Pin, Quick Release

Location

Loc Qty

Loc Code

ST315

23

m136593

23

210 Each

4.0000

1 3

**

JUL 25 2017

DAS

19

9-89

MS17984-C418

Purchased No

MS17984-C418

QUICK RELEASE PIN

Location

Loc Qty

Loc Code

FG

1

123482

1

ST315

3

m137963

3

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

Page 3

Wednesday, June 21, 2017 3:33:52 PM

Work Order ID: 163121

163121

Parent Item: D5350-043

D5350-043

Parent Item Name: Aft Beam Assembly

Start Date: 7/10/2017

Required Date: 7/20/2017

Start Qty: 3.00

Required Qty: 3.00

MS17984-C517

Purchased

No

210

Each

4.0000

2

6

MS17984-C517

Pin, Quick Release

**

JUL 25 2017

DAS
19
9-89

Location

Loc Qty

Loc Code

GA

m137528

4

4

~~138014~~

~~28~~

Wednesday, June 21, 2017 3:33:52 PM

Shop Packet Print

Page 3

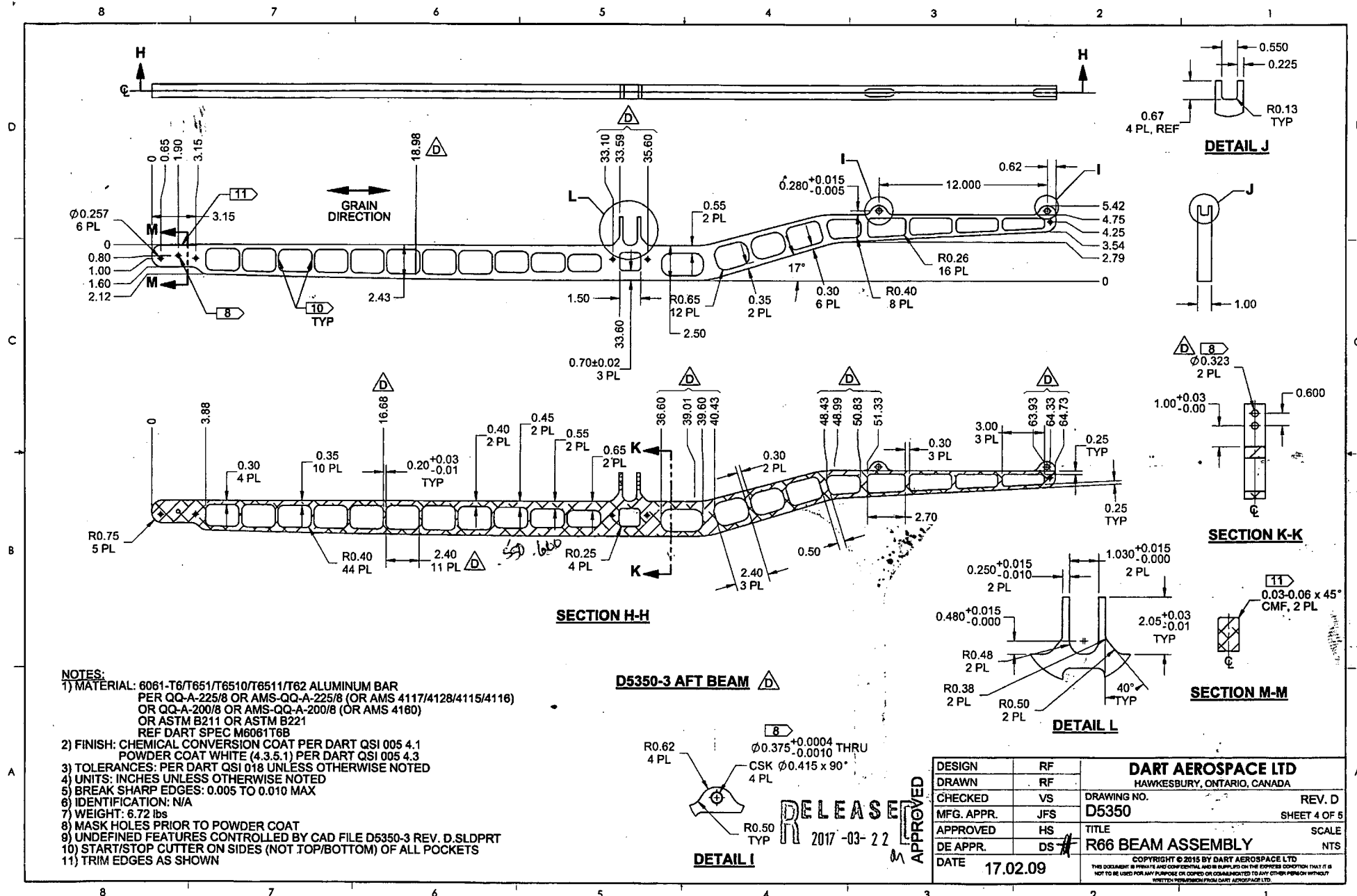
DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

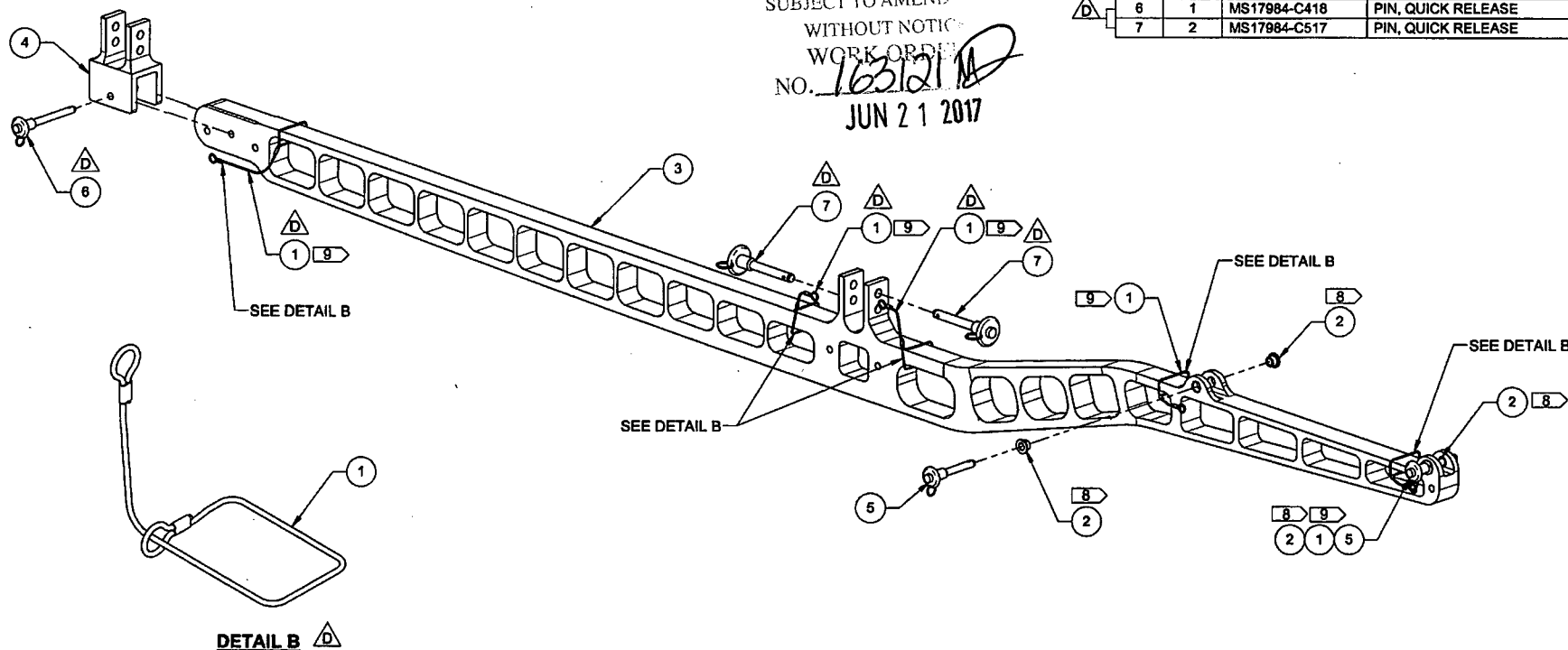
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Wafer Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																																																																																																																											
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Misidentified	☐	Past Due	☐																																																																																																																																																												



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED
SUBJECT TO AMEND
WITHOUT NOTICE
WORK ORDER
NO. 163121
JUN 21 2017

ITEM	QTY -043	P/N	DESCRIPTION
	X	D5350-043	R66 AFT CROSS BEAM ASSEMBLY
1	1	D2690-8	LANYARD ASSEMBLY
2	4	D5346-3	BUSHING
3	1	D5350-3	R66 AFT CROSS BEAM
4	1	D5350-5	ADAPTER
5	2	MS17984-C412	PIN, QUICK RELEASE
6	1	MS17984-C418	PIN, QUICK RELEASE
7	2	MS17984-C517	PIN, QUICK RELEASE



D5350-043 R66 AFT CROSS BEAM ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 7.10 lbs
- 8) PRESS FIT D5346-3 BUSHING INTO D5350-3 BEAM
- 9) ASSEMBLE D2690-8 WITH MS17984-C412/-C418/-C517 AS SHOWN

RELEASED
2017-03-22

APPROVED

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	VS	DRAWING NO.	REV. D
MFG. APPR.	JFS	D5350	SHEET 2 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	R66 BEAM ASSEMBLY	NTS
DATE	17.02.09	COPYRIGHT © 2015 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

DART AEROSPACE LTD		Work Order: 163121
Description: AFT Beam		Part Number: D5350-3
Inspection Dwg: D5350 Rev: D		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.80	+/- .030	.800	✓		Vern Mk08	
1.00	+/- .030	1.000	✓		"	
1.60	+/- .030	1.600	✓		"	
2.12	+/- .030	2.120	✓		"	
.65	+/- .030	.650	✓		"	
1.90	+/- .030	1.900	✓		"	
3.15	+/- .030	3.150	✓		"	
Ø .257	+ .006 / - .001	Ø .258	✓		"	
2.43	+/- .030	2.425	✓		"	
33.10	+/- .030	33.100	✓		M-type	
33.59	+/- .030	33.590	✓		"	
35.60	+/- .030	35.600	✓		"	
33.60	+/- .030	33.600	✓		"	
2.50	+/- .030	2.500	✓		Vern Mk08	
.55	+/- .030	.550	✓		"	
1.50	+/- .030	1.500	✓		"	
.35	+/- .030	.350	✓		"	
.30	+/- .030	.300	✓		"	
.280	+ .015 / - .005	.279	✓		"	
12.000	+/- .010	12.000	✓		"	
.62	+/- .030	.620	✓		"	
5.42	+/- .030	5.422	✓		"	
4.75	+/- .030	4.747	✓		"	

Measured by: <i>[Signature]</i>	Audited by: <i>[Signature]</i>	Preliminary Approval:
Date: 17/07/18	Date: 17/07/19	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

DART AEROSPACE LTD		Work Order: 163121
Description: AFT Beacon		Part Number: D5350-3
Inspection Dwg: D5350 Rev: D		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.25	+/- .030	4.243	✓		Vern H-08	
3.54	+/- .030	3.541	✓		"	
2.79	+/- .030	2.790	✓		"	
.550	+/- .010	.553	✓		"	
.225	+/- .010	.221	✓		"	
.67	+/- .030	.667	✓		"	
R.13	+/- .030	R.125	✓		R-6	
1.00	+/- .030	1.000	✓		Vern H-08	
∅ .323	+ .006 / - .0001					
1.00	+ .030 / - .000					
.600	+/- .010					
.030-.060x45°		.050	✓		Vern H-08	
1.030	+ .015 / - .000	1.031	✓		"	
.250	+ .015 / - .010	.249	✓		"	
2.05	+ .030 / - .010		✓		"	
.480	+ .015 / - .000	.480	✓		"	
R.38	+/- .030	R.380	✓		"	
R.50	+/- .030	R.500	✓		"	
∅ .375	+ .0004 / - .0010	∅ .3745	✓		"	
Gsk .415 x 90°	+/- .010	.409 x 90°	✓		"	
R .62	+/- .030	R .620	✓		R-6	
R .50	+/- .030	R .500	✓		"	
R .75	+/- .030	R .750	✓		"	

DAS

Measured by: 	Audited by: 33 9-89	Preliminary Approval:
Date: 17/07/18	Date: 17/07/19	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

DART AEROSPACE LTD		Work Order: 163121
Description: AS1 Beam		Part Number: DS350-3
Inspection Dwg: DS350 Rev: D		Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.88	+/- .030	3.876	—		Vern H/L	
.30	+/- .030	.300	—		"	
.35	+/- .030	.350	—		"	
16.68	+/- .030	16.680	—		M-type	
.20	+ .030 / - .040	.200	—		Vern H/L	
2.40	+/- .030	2.400	—		"	
.40	+/- .030	.400	—		"	
.45	+/- .030	.450	—			
.55	+/- .030	.550	—			
.65	+/- .030	.650	—		"	
R.025	+/- .030	R.250	—		R-G	
R.40	+/- .030	R.400	—		"	
2.40	+/- .030	2.400	—		Vern H/L	
.30	+/- .030	.300	—		"	
.50	+/- .030	.500	—		"	
2.70	+/- .030	2.700	—			
.30	+/- .030	.300	—			
3.00	+/- .030	3.000	—			
.25 Typ	+/- .030	.250	—			
.25 Typ	+/- .030	.250	—			
36.60	+/- .030	36.600	—		M-type	
39.01	+/- .030	39.010	—		"	
39.60	+/- .030	39.600	—		"	
40.43	+/- .030	40.430	—		"	
48.43	+/- .030	48.430	—		"	
48.99	+/- .030	48.990	—		"	
50.83	+/- .030	50.830	—		"	
51.33	+/- .030	51.330	—		"	
63.93	+/- .030	63.930	—		"	
64.33	+/- .030	64.330	—		"	
64.73	+/- .030	64.730	—		"	
			DAS		"	

Measured by: <i>mf</i>	Checked by: 33	QC Inspector:
Date: 17/07/18	Date: 17/07/19	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
B	14.07.31	New Issue	KJ	